

Date: Tuesday, 21/10/2008 7:06:02 AM  
 User: Linda Lacelle

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : PILOT CYCLIC STICK EXTENSION  
 Job Number : 42749  
 Estimate Number : 13111  
 P.O. Number :  
 This Issue : 21/10/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D36331  
 First Issue : / / Type : MACHINED PARTS Drawing Number : D3633 REV A  
 Previous Run : Project Number : N/A  
 Material : A  
 Due Date : 28/10/2008 Qty: 3 Um: Each  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev:A New Issue 07-12-19 DD

## Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

M6061T6R1250

6061-T6 Round Bar 1.250



③

Comment: Qty.: 0.1743 f(s)/Unit Total: 0.5229 f(s)

6061-T6 Round Bar 1.250

Batch: M 15/20

mmt 08/10/21

2.0

LATHE CONV.

CONVENTIONAL LATHE



③

Comment: CONVENTIONAL LATHE

Turn as per Dwg D3633

mmt 08/10/21

3.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



③

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmt 08/10/21

4.0

QC8

SECOND CHECK



③

Comment: SECOND CHECK

mmt 08/10/21

5.0

PACKAGING 1

PACKAGING RESOURCE #1



③

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 367

8/10/22

Sc

6.0

QC21

FINAL INSPECTION/W/O RELEASE



08/10/22

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mmt 08/10/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

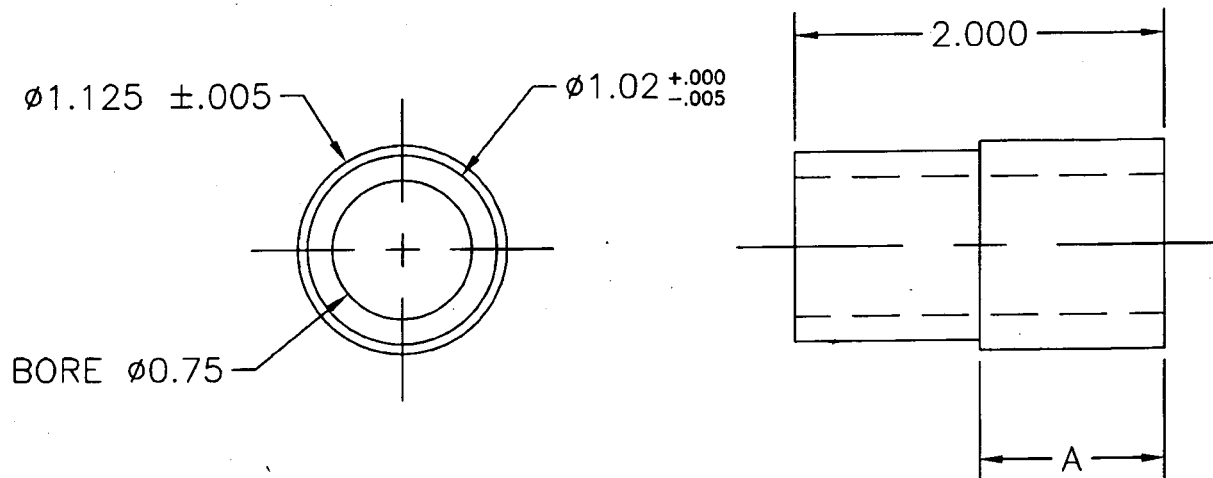
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



DESIGN CLB	DRAWN BY JC	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3633	REV. A SHEET 1 OF 1
DATE 07.05.14		TITLE CYCLIC STICK EXTENSION	SCALE 1:1
A	07.05.14	NEW ISSUE: REPLACES G10203/G10205	

RELEASED  
07-08-08 [Signature]



P/N	DESCRIPTION	DIM. "A"	REPLACES GENEVA P/N
D3633-1	PILOT CYCLIC STICK EXTENSION	1.00 $\pm$ 0.020	G10203
D3633-3	CO-PILOT CYCLIC STICK EXTENSION	1.30 $\pm$ 0.020	G10205

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC M6061T6R1.250)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N "D3633-X" USING FINE POINT PERMANENT INK MARKER

WLO 42749

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b> 42749
<b>Description:</b> <i>Pro: CYCLIC STICK EXTENSION</i>	<b>Part Number:</b> 03633-1
<b>Inspection Dwg:</b> D3633, <b>Rev:</b> 4	<b>Page 1 of 1</b>

# FIRST ARTICLE INSPECTION CHECKLIST

**X**


## First Article



## Prototype

[illegible]

Measured by:	MMT
Date:	08/10/21

<b>Audited by:</b>	
<b>Date:</b>	08/10/21

Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	